

SPLIT

Dart Aerospace Ltd.

Date: Thursday, 11/9/2006 4:36:02 PM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: HELI-ACCESS STEP LH (FOLDING)		
Job Number	: 29384 ✓		Part Number	: D412630033		
Estimate Number	: 12567		Drawing Number	: IIN D412-630 REV K		
P.O. Number	: N/A		Project Number	: N/A		
This Issue	: 11/9/2006	S.O. No. : N/A	Drawing Revision	: K		
Prsht Rev.	: NC		Material	: N/A		
First Issue	: N/A		Due Date	: 11/27/2006		
Previous Run	: N/A		Qty:	4		
Written By	: ✓		Um:	Each		
Checked & Approved By	: ✓ 06/11/06					
Comment	: Est. Rev:A New Issue 06-11-08 JLM					

Additional Product

Job Number:

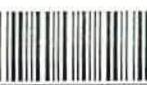


Seq. #:	Machine Or Operation:	Description :	
1.0	DC	DOCUMENT CONTROL	
		Comment: DOCUMENT CONTROL Photocopy bluefile & create labels per PPP D412-630-033 CHG001	
2.0	D2012107	Clevis	
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s) Clevis Pick: Qty Part Number Description Batch	
		X 1 D2012-107 Clevis B27522 x 3 mx	
3.0	D2803041	Bracket Assembly	
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s) Bracket Assembly Pick: Qty Part Number Description Batch	
		X 1 D2803-041 Bracket Assembly LH B29391 x 3 mx	
4.0	D2804041	Bracket Assembly	
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s) Bracket Assembly Pick: Qty Part Number Description Batch	
		X 1 D2804-041 Bracket Assembly LH B27102 x 3 mx	
		<i>11/02/06</i>	
		D2808 Bushing B28600 x 6 mx	

REFERENCE ONLY

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5.0	D2807	Support Prop 	
Comment: Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s) Support Prop Pick: Qty Part Number Description Batch			<i>4 B27562 x 8mx B22646 x 2mx</i>
6.0	D2813	Washer 	
Comment: Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s) Washer Pick: Qty Part Number Description Batch			<i>B29396 x 6mx</i>
7.0	D3562041	STEP ASSEMBLY, LH 	
Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s) Step Weldment LH Pick: Qty Part Number Description Batch			<i>B29411 x 3mx</i>
8.0	D33951	Bushing 	
Comment: Qty.: 4.0000 Each(s)/Unit Total : 20.0000 Each(s) Bushing Pick: Qty Part Number Description Batch			<i>B28455 x 12mx</i>
9.0	AN3C21A	BOLT 	
Comment: Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s) BOLT Pick: Qty Part Number Description Batch			<i>m101189 x 6mx</i>

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Job Number:



Seq. #: Machine Or Operation:

Description :

10.0 AN8C16 Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s)

Bolt

Pick:

Qty	Part Number	Description	Batch
2	AN8C16	Bolt	m100695 x 6mx

11.0 AN310C8 Nut



Comment: Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s)

Nut

Pick:

Qty	Part Number	Description	Batch
2	AN310C8	Nut	m100433 x 6mx

12.0 MS24665302 Cotter Pin



Comment: Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s)

Cotter Pin

Pick:

Qty	Part Number	Description	Batch
2	MS24665-302	Cotter Pin (or AN380C3-4)	m16941 x 6mx

13.0 NAS1515H3 Washer



Comment: Qty.: 6.0000 Each(s)/Unit Total : 30.0000 Each(s)

Washer

Pick:

Qty	Part Number	Description	Batch
6	NAS1515H3	Washer	m100993 x 18mx

14.0 NAS1515H5L WASHER



Comment: Qty.: 4.0000 Each(s)/Unit Total : 20.0000 Each(s)

WASHER

Pick:

Qty	Part Number	Description	Batch
4	NAS1515H5L	Washer	m100683 x 12mx

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Job Number:



Seq. #:	Machine Or Operation:	Description :
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15.0	NAS1515H8	Washer
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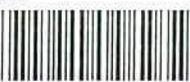
Comment: Qty.: 4.0000 Each(s)/Unit Total : 20.0000 Each(s)

Washer

Pick:

Qty	Part Number	Description	Batch
4	NAS1515H8	Washer	<u>M102067</u>

16.0	MS210433	Nut
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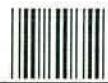
Comment: Qty.: 4.0000 Each(s)/Unit Total : 20.0000 Each(s)

Nut

Pick:

Qty	Part Number	Description	Batch
4	MS21043-3	Nut	<u>M102545</u>

17.0	MS24693C280	Screw
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s)

Screw

Pick:

Qty	Part Number	Description	Batch
2	MS24693-C280	Screw (or MS24694-C565)	<u>M101390</u>

18.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble as per dwg D412-630 p.14

MF. 07-02-01

Coat all hardware with LPS3 rust inhibitor
A/R LPS3 batch: M101472

COAT exposed HARDWARE WITH LPS PROCYON.

MF. 07-02-01

A/R LPS PROCYON BATCH: M17045

19.0	QC5	INSPECT WORK TO CURRENT STEP
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Comment: INSPECT WORK TO CURRENT STEP

86 07/02/01

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Job Number:



Seq. #: Machine Or Operation:

Description :

20.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

21.0 D28061

Bushing



Comment: Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s)

Bushing

Pick: Packing Kit

Qty	Part Number	Description	Batch
2	D2806-1	Bushing	<u>B27285</u> 6X ✓

22.0 D28063

Bushing



Comment: Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s)

Bushing

Pick: Packing Kit

Qty	Part Number	Description	Batch
2	D2806-3	Bushing	<u>B27286</u> 2X <u>B28163</u> 4X ✓

23.0 D28105

Strut



Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)

Strut

Pick: Packing Kit

Qty	Part Number	Description	Batch
1	D2810-5	Strut	<u>B27103</u> 3X ✓

24.0 D33961

Spacer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s)

Spacer

Pick: Packing Kit

Qty	Part Number	Description	Batch
2	D3396-1	Spacer	<u>B27290</u> 6X ✓

25.0 AN4C6A

Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)

Bolt

Pick: Packing Kit

Qty	Part Number	Description	Batch
1	AN4C6A	Bolt	<u>M100651</u> 3X ✓

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Job Number:



Seq. #: Machine Or Operation:

Description :

1 AN4C6A Bolt

26.0 AN4C10A Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)

Bolt

Pick: Packing Kit

Qty	Part Number	Description	Batch
1	AN4C10A	Bolt	M100273

27.0 AN4C15A Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s)

Bolt

Pick: Packing Kit

Qty	Part Number	Description	Batch
2	AN4C15A	Bolt	M100447

28.0 AN44C7A Eyebolt



Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)

Eyebolt

Pick: Packing Kit

Qty	Part Number	Description	Batch
1	AN44-C7A	Eyebolt	M101711

29.0 AN5C15A Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s)

Bolt

Pick: Packing Kit

Qty	Part Number	Description	Batch
2	AN5C15A	Bolt	M100447

30.0 NAS1515H4 Washer



Comment: Qty.: 7.0000 Each(s)/Unit Total : 35.0000 Each(s)

Washer

Pick: Packing Kit

Qty	Part Number	Description	Batch
7	NAS1515H4	Washer	M101428

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Part Number: D412630033

Job Number:



Seq. #: Machine Or Operation:

Description :

31.0 NAS1515H5 Washer



Comment: Qty.: 7.0000 Each(s)/Unit Total : 35.0000 Each(s)

Washer

Pick: Packing Kit

Qty Part Number
7 NAS1515H5

Description
Washer

Batch

M101369 16x M101064 5X ✓

32.0 MS210434 Nut



Comment: Qty.: 4.0000 Each(s)/Unit Total : 20.0000 Each(s)

Nut

Pick: Packing Kit

Qty Part Number
4 MS21043-4

Description
Nut

Batch

M101390-12X ✓

33.0 MS210435 Nut



Comment: Qty.: 3.0000 Each(s)/Unit Total : 15.0000 Each(s)

Nut

Pick: Packing Kit

Qty Part Number
3 MS21043-5

Description
Nut

Batch

M101418 6X ✓ ~~M101418~~ ✓ *18535 3X ?*

34.0 QC4 INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

07/02/13 (3)

35.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D412-630-033

Location:

PPP Rev: *Draft*

07/02/13 (3)

36.0 QC21 FINAL INSPECTION/W/O RELEASE



07/02/13 (3)

Comment: FINAL INSPECTION/W/O RELEASE

07/02/13

Job Completion

